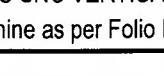
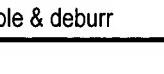


Date: Tuesday, 4/4/2006 1:26:43 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LITTER TIE DOWN ASS'Y	
Job Number	: 26488				
Estimate Number	: 10360				
P.O. Number	: N/A		Part Number	: D2350	
This Issue	: 4/4/2006	S.O. No. : N/A	Drawing Number	: D2350 / D2363	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B/E	
Previous Run	: 26442		Material	: N/A	
Written By	: See JF COMMENT BELOW		Due Date	: 4/24/2006	
Checked & Approved By	: JF 06.04.04			Qty:	4 Um: Each
Comment	:				
Additional Product					
Job Number: 					
Seq. #:	Machine Or Operation:	Description :			
1.0	D6201	T Extrusion 4X4X3/8 			
Comment: Qty.: 1.0631 f(s)/Unit Total : 4.2525 f(s) Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion Batch: P 26538					
2.0	BAND SAW	BAND SAW 			
Comment: BAND SAW Cut blanks: 12.150" long 					
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 			
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio D2363 and Dwg D2363 					
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 					
5.0	QC8	SECOND CHECK 			
Comment: SECOND CHECK 					
6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 			
Comment: HAAS CNC VERTICAL MACHINING #1 Tumble & deburr 					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:26:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: LITTER TIE DOWN ASS'Y
Job Number: 26488		Part Number: D2350
Job Number:		
Seq. #:	Machine Or Operation:	Description :
7.0	QC5	INSPECT WORK TO CURRENT STEP
		
		<i>Jawes 08</i>
Comment: INSPECT WORK TO CURRENT STEP		
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
		
Comment: HAND FINISHING RESOURCE #1		<i>H.M 06/05/09</i>
Chemical Conversion Coat as per QSI 005 4.1		<i>(4)</i>
9.0	POWDER COATING	POWDER COATING
		
		
Comment: POWDER COATING		
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		<i>a.m 06-05-16</i>
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
		
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
11.0	D2372	Quick Release
		
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Pick: Assembly Kit		
Qty Part Number Description Batch		
2 D2372 Fastener <i>B19507</i>		
12.0	D2444	Pip Pin Assembly
		
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick: Assembly Kit		
Qty Part Number Description Batch		
1 D2444 Pip Pin <i>B25824</i>		
13.0	AN960JD10L	Washer
		
		
Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)		
Pick: Assembly Kit		
Qty Part Number Description Batch		
3 AN960JD10L Washer <i>M18235</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:26:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 26488

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) M18917

15.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13 Screw M13719

SAP 05.05.17 (4)

16.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST171

14/01/19 (4)

18.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

14/01/19 (4)

Job Completion



U 06.05.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.05.17	15.1	Assy as per Dwg. Add to estimate - permanent change J 06.05.17	SAD	06.05.17	1	 06.05.17	 06.05.17

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06.05.17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.05.17	15.1	1x D2372 was damaged by the drill chuck, when removing the handle part out of the pippin holes.	 06.05.17	Scrap & replace 1x D2372.	SAD 06.05.18	 06.05.17	 06.05.17	 06.05.17

NOTE: Date & initial all entries

DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>JF</i>	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY	SCALE

RELEASED
 960667

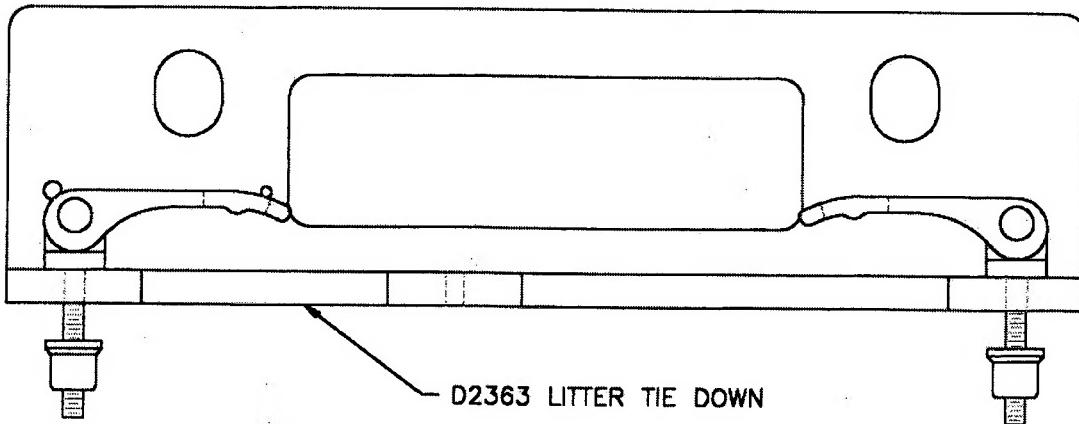
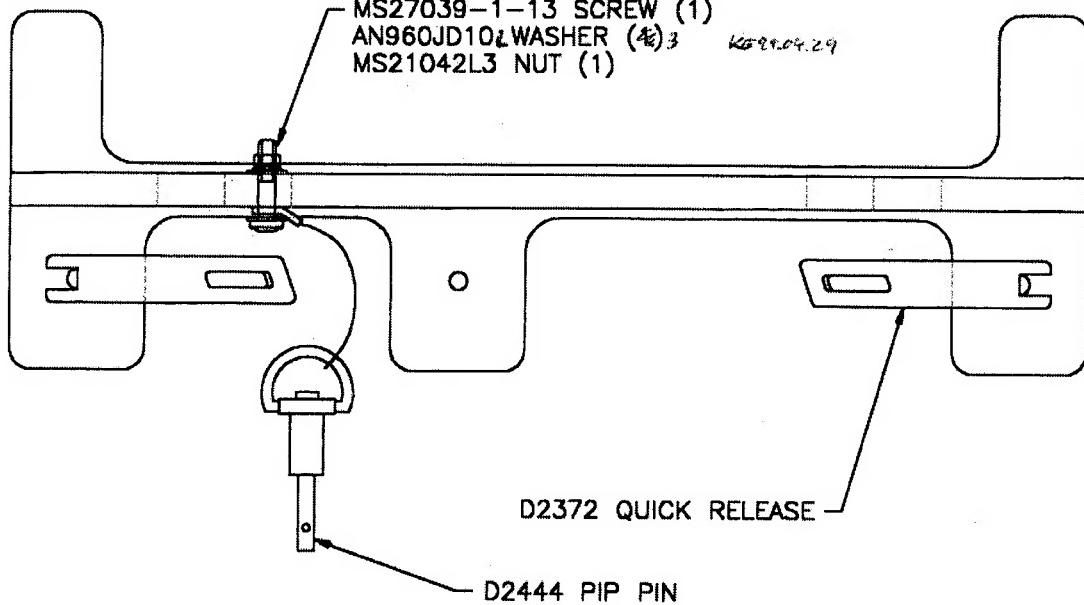
D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
<i>X 3</i>	AD960JD10 L	WASHER
1	MS21042L3	NUT
1	MS27039-A-13	SCREW

KE 99.04.29

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 WITHOUT NOTICE
 WORK ORDER
 NO. *26488*

DART

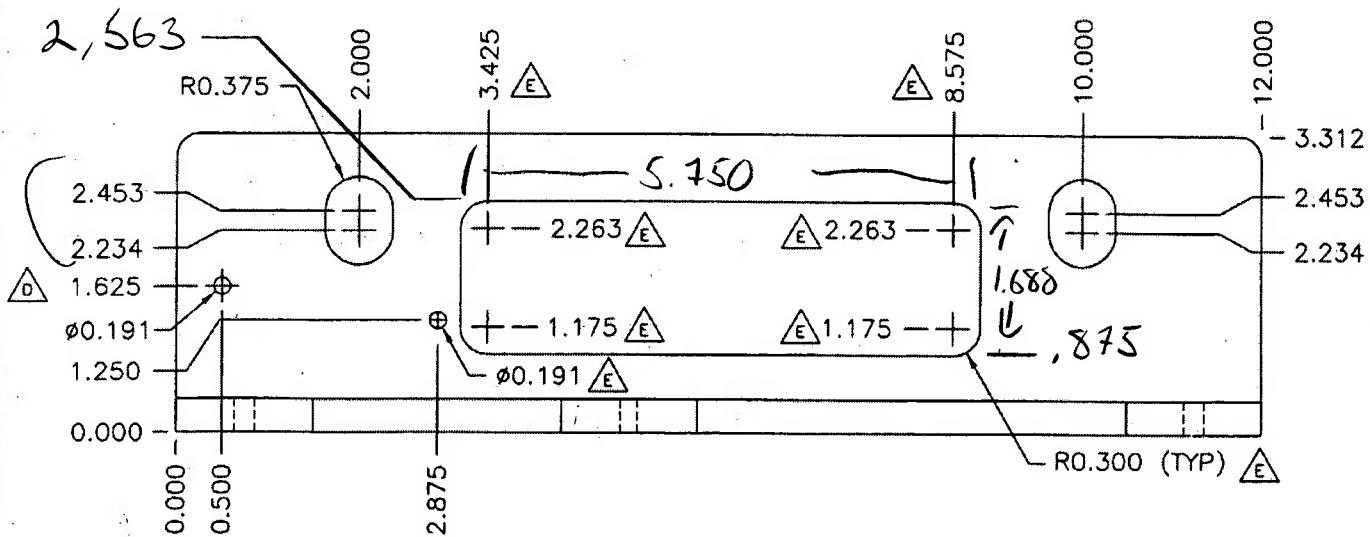
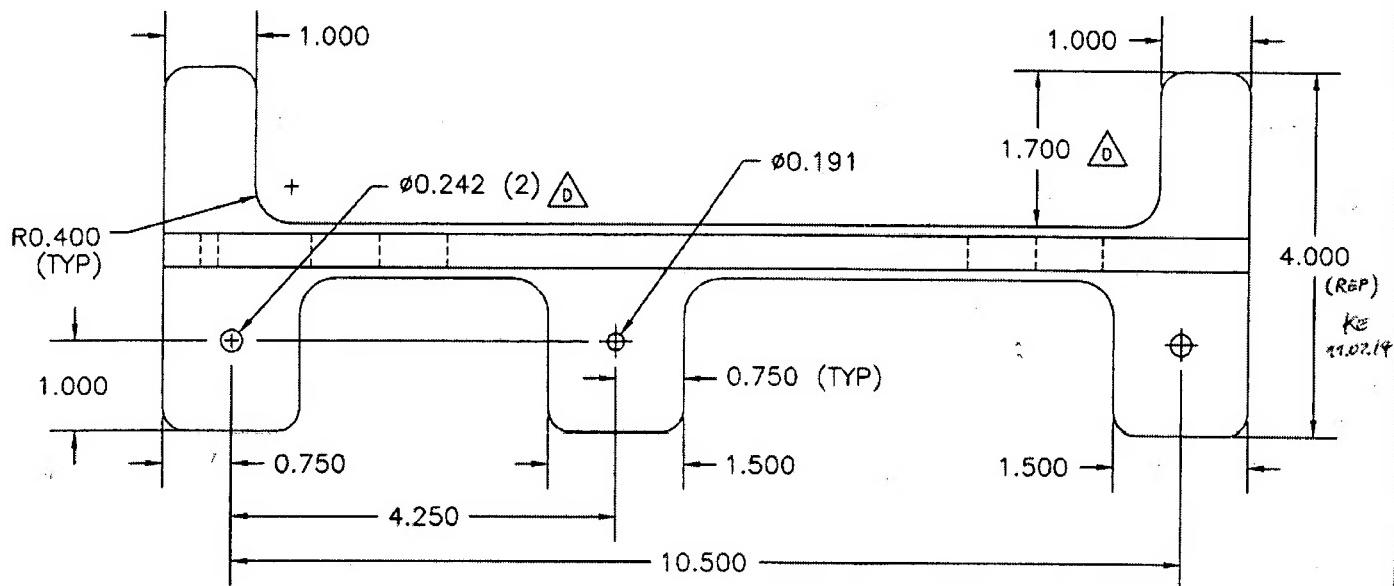
DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2350	REV. B SHEET 2 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY	SCALE

RELEASED
96 06 07

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WORK ORDER
NO. 26488

DART

DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED D100Y	APPROVED BW	DRAWING NO. D2363	REV. E SHEET 1 OF 1
DATE 97.10.01		TITLE LITTER TIE DOWN BRACKET	SCALE 1:2

RELEASED
 971003 KE
 TSR A129

 MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION
 FINISH: ANODIZE

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 WITHOUT NOTICE

 WORK ORDER
 NO. 264188

Work Order:	W.O. #
Rev:	
Part Number:	
Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Dimension

Tolerance

Actual Dimension

Accept

Reject

Method of Inspection

Comments

Measured by	S
Date:	06.06.06

Audited by	R
Date:	06.05.06

Prototype Approval:	
Approved by	KJRF
Date:	